

Work Order ID 58763-15 split ship 28/05

May 18, 2010 1:41:16 PM

Page 1

Item ID: D3183-045

Revision ID:

Item Name: Bearing Assembly

Start Date: 5/18/10 Start Qty: 110.00

Required Date: 5/28/10 Req'd Qty: 110.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn D3183-9 Cap as per Folio FA388 Deburr

0.00

0.00

110 *φ*

*SA 10/05/19*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

110 *φ*

*SA 10/05/19*

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*SA 10/05/20*

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Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 5/18/10

Start Qty: 110.00



Cust Item ID:

Required Date: 5/28/10

Req'd Qty: 110.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

0.00

0.00

u 1005-20 (5)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Suberbo

(75)

150



Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

10-5-2004 (508)

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Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 5/18/10 Start Qty: 110.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 110.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/20  
ME  
10-5-19

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**Required Date:** 5/28/10

**Required Qty: 110.00**

Bearing

Delrin Round Bar 1"

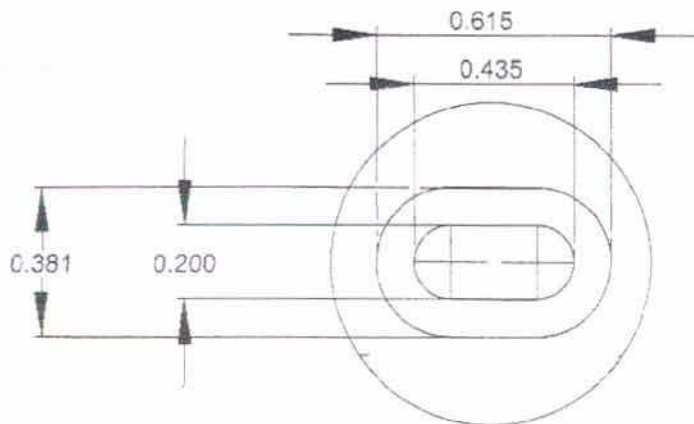
u for  
SD 10.05.20



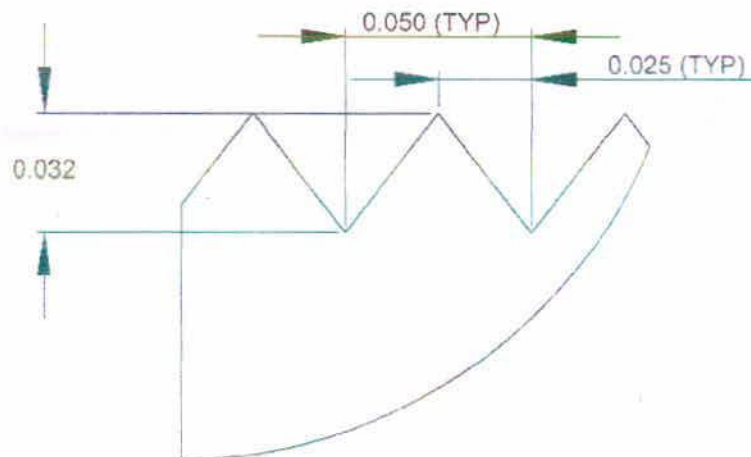


**DART**

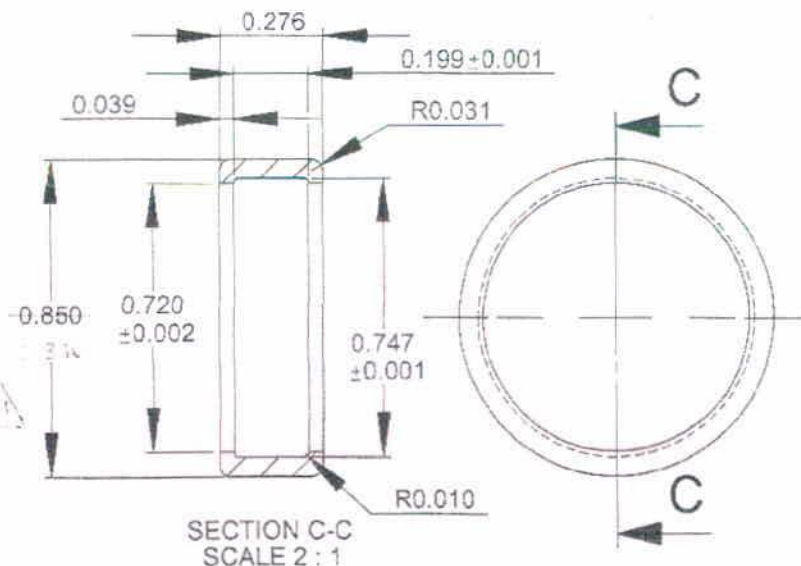
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



DETAIL A (2 : 1)

*W/O 58763*RELEASED  
04-03-01

DETAIL B (20 : 1)

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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